

Work Order ID 138168

138168

Tuesday, October 27, 2015 11:05:04 AM

Page 1

Item ID: D412-698-013 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Cabin Door Handle -Aluminum Door
 Start Date: 10/16/2015 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 10/26/2015 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: ML3 Date: OCT 27 2015 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN D412-698	Rev E								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D412-698-013CHG001								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

ML3 16-01-21 (2)

2 DAS 28 9-89 JAN 25 2016

2 JAN 21 2016 DAS 28 9-89

2 DAS 28 9-89 JAN 25 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
Misidentified	☐	Past Due	☐								

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Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Cabin Door Handle -Aluminum Door

Start Date: 10/16/2015 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 10/26/2015 Req'd Qty: 2.00 ***2***

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00				2	DAS 28 9-89	JAN 25 2016	
Packaging	Identify and pack for shipping as per PPP D412-698-013 Location:FG022								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

20160125

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Work Order ID: 138168

138168

Parent Item: D412-698-013

D412-698-013

Parent Item Name: Cabin Door Handle -Aluminum Door

Start Date: 10/16/2015

Required Date: 10/26/2015

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev: C Removed Manufacturing 05-11-06 JLM
IPP Rev:D change to rev D ECN 1104 08-01-28 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued DAS	Status
2 *D3203-1* Handle		Manufactured	No				Each	20.0000	4 **	8		6 9-89	27 9-89
	DAS 28 9-89			<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST483			20						
				130880			13			5			
				135844			7			3			
2 *D3220-041* Doubler Assembly		Manufactured	No				Each	2.0000	1 **	2		6 9-89	27 9-89
	DAS 28 9-89			<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST484			2						
				133193			2						
2 *D3220-042* Doubler Assembly		Manufactured	No				Each	3.0000	1 **	2		6 9-89	27 9-89
	DAS 28 9-89			<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST484			3						
				112411			1						
				133141			2			2			
2 *D3220-3* Doubler		Manufactured	No				Each	9.0000	0 **	4		6 9-89	27 9-89
	DAS 28 9-89			<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST485			9						
				130481			9			4			

JAN 21 2016

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Root Cause				FAULT CATEGORY			
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Design	☐	Operator	☐	Bending	☐	Set-up	☐
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Page 2

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Parent Item: D412-698-013

D412-698-013

Parent Item Name: Cabin Door Handle -Aluminum Door

Start Date: 10/16/2015

Required Date: 10/26/2015

Start Qty: 2.00

Required Qty: 2.00

MS21042L4

Purchased

No

Each

2,608.000

16

2 ***MS21042L4***

Locknut

**

133769

DAS
6
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

CCK004

2000

m133363

2000

FP001

2

m124231

2

GA

67

m127813

67

ST260a

138

m130799

56

m131803

6

m132262

76

ST305

401

m128300

8

m130388

7

m130922

97

m131618

12

m132123

56

m132382

121

m133316

100

DAS
28
9-89

MS24694-S98

Purchased

No

Each

71.0000

16

32

2 ***MS24694-S98***

Screw

**

DAS
6
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST288

71

m128606

1

m132536

70

DAS
28
9-89

30

JAN 21 2016

DQA: _____ Date: _____



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Page 3

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D412-698-013

Parent Item Name: Cabin Door Handle -Aluminum Door

Start Date: 10/16/2015

Required Date: 10/26/2015

Start Qty: 2.00

Required Qty: 2.00

NAS1149D0416J

Purchased

No

Each

4,569.000

16

NAS1149D0416.J

WASHER

**

DAS
28
9-89

JAN 21 2016
DAS
27
9-39

Location

Loc Qty

Loc Code

GA

347

m131511

347

ST260a

2000

m131511

2000

ST270

2222

m131511

2222

DAS
28
9-89

16

DQA: _____ Date: _____



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6.0 PARTS LIST - CABIN DOOR MODIFICATION KITS

(FOR AIRCRAFT EQUIPPED WITH P/N 205-032-669-XXX ALUMINUM DOORS)

Qty -011	Qty -012	Qty -013	Qty -017	Qty -019	Qty -021	Part Number	Description
X						D412-698-011	CABIN DOOR ROLLER KIT, LH
	X					D412-698-012	CABIN DOOR ROLLER KIT, RH
		X				D412-698-013	DOOR HANDLE KIT
			X			D412-698-017	REPLACEMENT DOOR TRACK KIT
				X		D412-698-019	BEARING OVERHAUL KIT
					X	D412-698-021	REPLACEMENT SHIM KIT
3	3					D3121-141	BRACKET ASSEMBLY
1						D3121-143	BRACKET ASSEMBLY
	1					D3121-144	BRACKET ASSEMBLY
1	1					D3137-043	BRACKET ASSEMBLY
1						D3183-043	BRACKET ASSEMBLY
	1					D3183-044	BRACKET ASSEMBLY
9	9		9			D3199-1	BRACKET
1	1		1			D3202-1	COVER
		4				D3203-1	HANDLE
		1				D3220-041	DOUBLER
		1				D3220-042	DOUBLER
		2				D3220-3	DOUBLER
				7		D3121-21	BOLT
				5		D3121-241	BEARING ASSEMBLY
				1		D3137-3	GUIDE
				1		D3137-5	WASHER
				2		D3183-045	BEARING ASSEMBLY
					3	D3238-1	SHIM
					1	D3238-3	SHIM
					2	D3238-5	SHIM
					6	D3238-11	SHIM
					2	D3238-13	SHIM
					4	D3238-15	SHIM
		8				AN960JD416L	WASHER
		8				MS21042L4	NUT (OR MS21042-4)
		16				MS24694-S98	SCREW
				1		MS24694-S101	SCREW